User

Friday, 25/07/2008 4:20:52 PM

Julie Lecoca

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 40763 : 13506

Estimate Number

P.O. Number

This Issue

: 25/07/2008

: NC Prsht Rev.

First Issue

Previous Run

: 11

Type

S.O. No. :

: SMALL /MED FAB

Part Number

Drawing Name

: D21951

Drawing Number Project Number : D2195 REV C : N/A : C

Drawing Revision

Material

Due Date

: 20/08/2008

: BRACKET

Qty:

2 Um:

Each

Checked & Approved By

Comment

Written By

08-07-24 new issue ec verified by:dd

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S16GA

Comment: Qty.: 0.2216 sf(s)/Unit Total:

0.4431 sf(s)

304 SS Sheet 0.063" thick

batch: 168 734

2.0

FLOW WATER JET

304/316 Sheet .063



Comment: FLOW WATER JET

1-Cut as per Dwg D2195

Dwg Rev:___

18 8-8-21

Prog Rev:_

2-Deburr if necessary

188-8-21

3.0

HB 8-8-21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE

Comment: NC BRAKE

Bend as per dwg D2195

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
	1										

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E	3	Verification						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
				•								
		•										

NOTE: Date & initial all entries

Friday, 25/07/2008 4:20:52 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 40763 Part Number: D21951 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Identify wiith Dart part # using a fine point permanent marker and Stock 1 08/08/06 Al Location & 8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE





Job Completion



Dart Aerospace Ltd

W/O:			WC	RK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHAI	NGE	В	у	Approval Chief Eng / Prod Mgr	Approval Chief Eng / Prod Mgr Approval QC Inspector		
`		• •								
	:									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es N	o DQ /	A :	Date:	
					Q	A: N/C	Close	d:	_ Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	MANCE (N	ICR)				
DATE	STEP	Description of NC		Corrective Action Section B			Verificatio			Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Section C		Chief Eng	QC Inspector
							<u>.</u>			
				·						
									,	

NOTE: Date & initial all entries





C

D2195-2

	DESIG	*	DRAWN BY	1	T AEROSPACE LTD	
7	CHECK	ED#	APPROVED.	DRAWING NO. D2195	SHEET	REV. C
	DATE			TITLE		SCALE
	03.0	5.28		BRACKET		1:2
	В		93.09.23	RE-DESIGN		

REDRAW; D2195-3 NOW 0.5" THICK

000 Ø0.128 4.10 - RO.50 (TYP ALL CORNERS) (TYP 6 PLACES) (D2195-3)- 4.000 Ø0.257 -3.625 Ω - 3.000 3.300 -- 2.688 0.203 (TYP 5 PLACES) - 1.750 D2195-1/-2 -0.300 0.813 (TYP) 0.375 0.500 D2195-1/-2/-3 0.000 FLAT PATTERN

03.05.28

D2195-1/-2 1) MATERIAL: AISI 304/316 S.S. 0.064" THICK (M304S16GA)

D2195 - 3

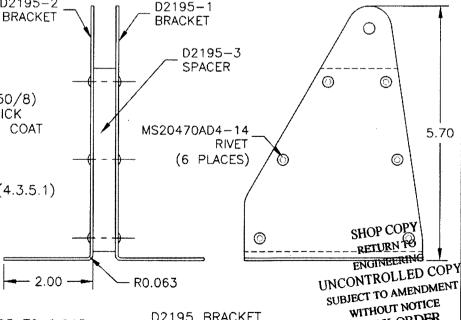
- 2) MATERIAL: 5052H32 (QQ-A-250/8) 0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

D2195 BRACKET (ASSEMBLY):

4) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2195 BRACKET

(ASSEMBLY)

WORK ORDER

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DARTAEROSPACE LTD	Work Order:	40763
Description: BRACKET	Part Number:	D2195-1
Inspection Dwg: D3/9(- Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
861. 8	1.005001	130	x			
\$,703	4 - 665001	,70 \$	*			
Ø . 257	1.006-001	.559	*			
.375	010.	375	*			
.813	4 .00	,816	<i>†</i>			
1.770	G101	1754	8			
7.688	4/- 010	OP3.6	<i>₹</i>			
3.625	4- ,010	3,631	×			
4.000	1/ 40	4,007	*			
.375	4010	.375	*			
006.1	1/2 -010	1 199	×			
2,390	7- 1010	2,390	*			
4.140	7- 010	4.143	a			
098,2	4 010	5,894	ধ			
	+1010	7,092	×			
7.590	4- 1010	7.593	4			
.663	1/010	,059	*			
			`			

			C			<u> </u>
Measured by:	IR	Audited by:		Prototype Approval:	N	
Date:	8-8-91	Date:	16/30/30	Date:		4

Rev	Date	Unungu	Revised by	Approved
Α		New Issue K	CJ/JLM	

